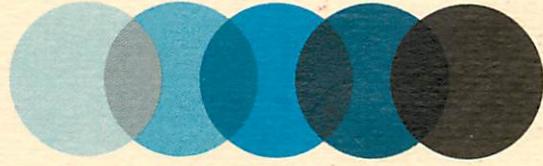


# Nebel

## MT-1308

## MT-1611



MICRO-TURN\*  
PRECISION LATHE

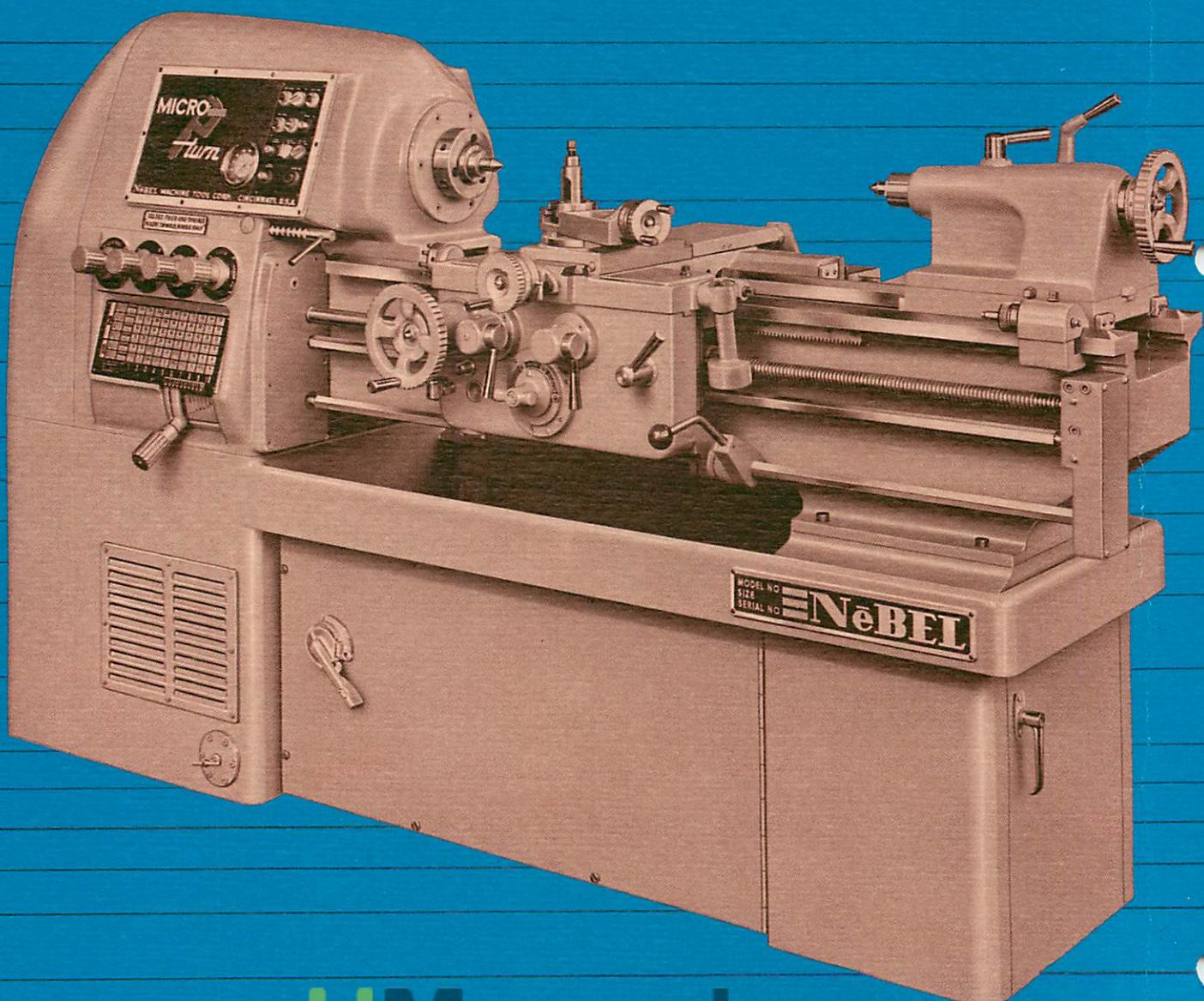
**Nebel** LATHE DIVISION • NEBEL MACHINE TOOL CORP. • CINCINNATI 15, OHIO

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NEBEL / MICRO-TURN

a completely new concept



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## END GEARING

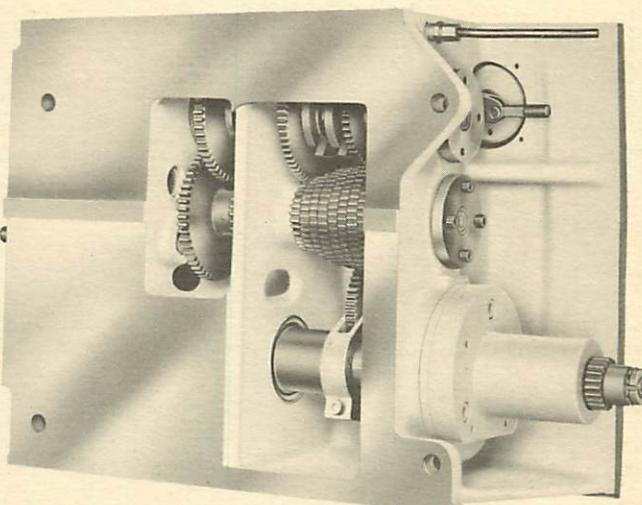
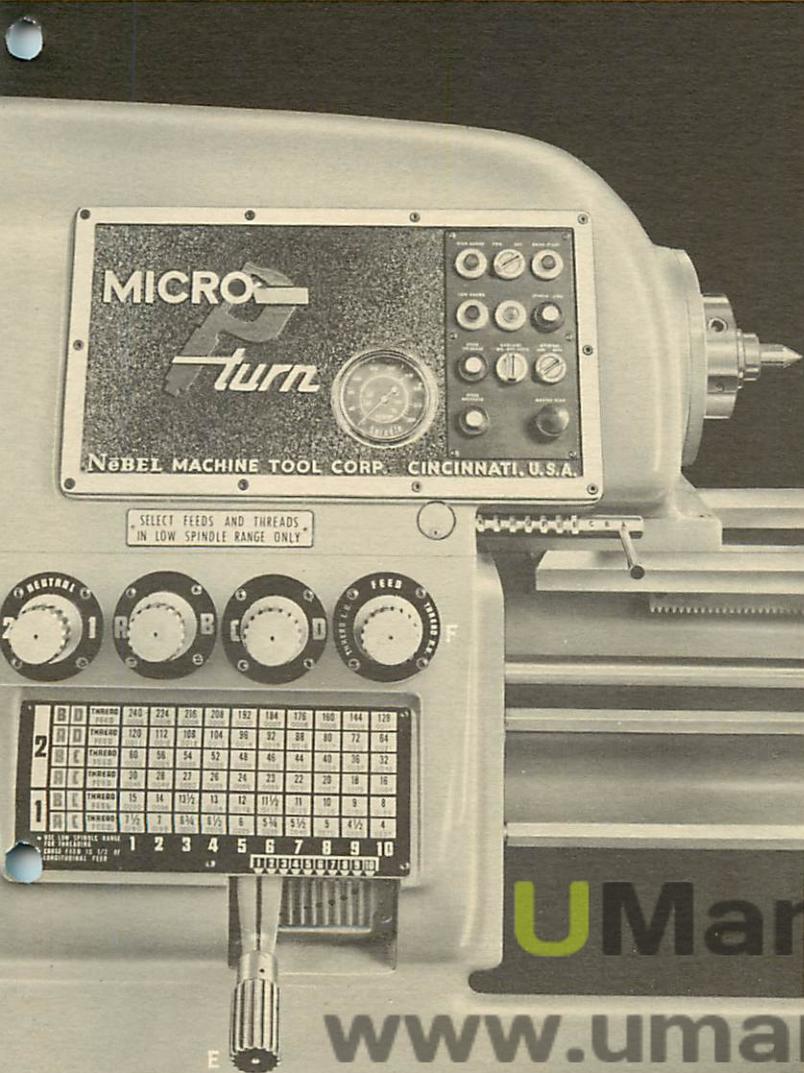
Power from the spindle to the gear box is obtained from the jack shaft through a positive gear drive to the totally enclosed, pressure-lubricated end gearing unit. All gears in this unit have shaved and hardened teeth to insure uniform wear when used in conjunction with the gear box for all feeding and threading operations. End-gear cover is easily removed to permit the quick changing of gears to obtain English or Metric threads.

## ENGLISH FEEDS AND THREADS

Thread	240	224	216	208	192	184	176	160	144	128
Feed	.0005	.0006	.0006	.0006	.0007	.0007	.0008	.0008	.0009	.0011
Thread	120	112	108	104	96	92	88	80	72	64
Feed	.0011	.0012	.0012	.0013	.0014	.0015	.0016	.0017	.0019	.0021
Thread	60	56	54	52	48	46	44	40	36	32
Feed	.0022	.0024	.0025	.0026	.0028	.0029	.0031	.0034	.0037	.0042
Thread	30	28	27	26	24	23	22	20	18	16
Feed	.0045	.0048	.0050	.0052	.0056	.0059	.0061	.0067	.0075	.0084
Thread	15	14	13½	13	12	11½	11	10	9	8
Feed	.0090	.0096	.0100	.0104	.0112	.0117	.0123	.0135	.0150	.0169
Thread	7½	7	6¼	6½	6	5¾	5½	5	4½	4
Feed	.0180	.0193	.0200	.0208	.0225	.0235	.0245	.0270	.0300	.0337

## METRIC FEEDS AND THREADS

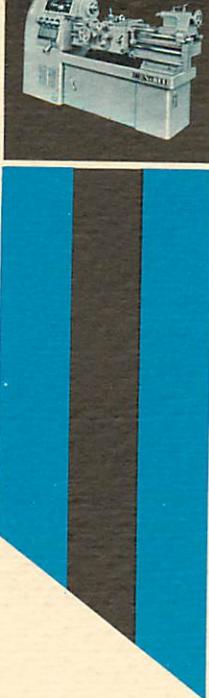
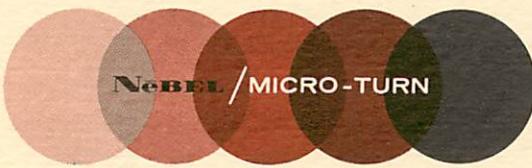
pitch MM	tumbler station	gear on stud A	gear on stud B	lever on
8.0	1	144	27	1-A-C
7.0	1	140	30	1-A-C
6.0	1	144	36	1-A-C
5.5	1	132	36	1-A-C
5.0	1	140	42	1-A-C
4.5	1	126	42	1-A-C
4.0	6	144	36	1-A-C
3.5	1	140	30	1-B-C
3.2	10	144	36	1-A-C
3.0	1	144	36	1-B-C
2.8	10	140	40	1-A-C
2.5	1	140	42	1-B-C
2.4	3	144	36	1-B-C
2.2	3	132	36	1-B-C
2.0	6	144	36	1-B-C
1.8	1	144	30	2-A-C
1.75	1	140	30	1-A-D
1.6	10	144	36	1-B-C
1.5	1	144	36	1-A-D
1.4	10	140	40	1-B-C
1.3	3	143	33	1-A-D
1.25	1	140	42	1-A-D
1.2	3	144	36	1-A-D
1.1	3	132	36	1-A-D
1.0	6	144	36	1-A-D
.90	1	144	30	2-B-C
.80	10	144	36	1-A-D
.75	1	144	36	1-B-D
.70	10	140	40	1-A-D
.60	3	144	36	2-B-C
.50	6	144	36	1-B-D
.45	1	144	30	2-A-D
.40	10	144	36	1-B-D
.375	1	144	36	2-A-D
.35	10	140	40	1-B-D
.325	3	143	33	2-A-D
.30	3	144	36	2-A-D
.275	3	132	36	2-A-D
.25	6	144	36	2-A-D
.225	1	144	30	2-B-D
.20	10	144	36	2-A-D



GEAR BOX—REAR VIEW

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## MT-1308 and MT-1611 specifications

<b>Capacity</b>	<b>MT-1308</b>	<b>MT-1611</b>	<b>Carriage</b>	<b>MT-1308</b>	<b>MT-1611</b>
Swing over bedways.....	13½"	16⅛"	Length on ways.....	18¾"	18¾"
Swing over carriage wings.....	13½"	16⅛"	Bearing surface, square inches.....	47½"	47½"
Swing over compound rest or cross slide.....	8"	11"	Cross slide, travel, with or without taper attachment.....	10"	10"
Swing over cross slide, with tracer.....	6"	9"	Compound rest travel.....	3½"	3½"
Distance between centers, base length.....	24"	24"	Bridge width.....	6¼"	6¼"
Center distance increase in increments.....	6"	6"	Lubrication, type.....	Pressure	Pressure
Size of tool.....	½" x 1⅛"	½" x 1⅛"			
Steady rest capacity.....	½" to 5½"	½" to 5½"			
Follow rest capacity.....	½" to 5½"	½" to 5½"			
Face plate, small diameter.....	12"	15"			
Driver plate.....	7½"	7½"			
<b>Headstock</b>					
Spindle speeds.....	Infinitely variable	Infinitely variable	<b>Feeds &amp; Threads</b>		
Spindle speed range.....	43/3500	43/3500	Feed changes, number.....	60	60
Spindle speed range, direct-belt drive.....	400-3500	400-3500	Feed range, standard.....	.0005"/.0337"	.0005"/.0337"
Spindle speed range, planetary drive.....	43-400	43-400	Feed range, optional.....	.001"/.0625"	.001"/.0625"
Spindle bearings, number.....	3	3	Thread changes, number.....	60	60
Journal diameters:			Threads per inch, range.....	4-240	4-240
Front.....	2¾"	2¾"	Leadscrew diameter.....	1"	1"
Center.....	2¾"	2¾"	Leadscrew threads per inch.....	4	4
Rear.....	1¾"	1¾"	Metric threads.....	41	41
Front spindle bearing:			Metric thread range.....	.20-8.0 mm	.20-8.0 mm
Outside diameter.....	415/16"	415/16"			
Radial load, 100 RPM, pounds.....	11,424	11,424			
Thrust load, 100 RPM, pounds.....	7,080	7,080			
Center spindle bearing:					
Outside diameter.....	3¾"	3¾"	<b>Taper Attachment</b>		
Radial load, 100 RPM, pounds.....	2,870	2,870	Maximum taper per foot (telescopic).....	20° incl. or 4"	20° incl. or 4"
Rear spindle bearing:			Turns at one setting (telescopic).....	14"	14"
Outside diameter.....	3½"	3½"			
Radial load, 100 RPM, pounds.....	2,000	2,000	<b>Tailstock</b>		
Spindle, size of hole, straight.....	1½"	1½"	Spindle diameter.....	2"	2"
Spindle, size of tapered hole.....	#5	#5	Center, Morse No.....	3	3
Spindle-size of center, Morse No.....	#3	#3	Spindle travel.....	6"	6"
Spindle nose—Camlock.....	4" D-1	5" D-1	Spindle set over, right or left.....	1"	1"
Headstock length on bed.....	24¾"	24¾"	Length on ways.....	11¾"	11¾"
<b>Bed</b>					
Length, base length (24").....	68⅛"	68⅛"	<b>Main Drive Motor</b>		
Length increases in increments of.....	6"	6"	Horsepower.....	5	5
Width across ways.....	12"	12"	R.P.M.....	1800	1800
Depth, standard bed, overall.....	10½"	10½"	Type Drive.....	Mechanical variator	Mechanical variator
Depth, standard bed, thru center section.....	9½"	9½"			

### Weight and Dimension (Center distance 24")

Net weight, pounds.....	2875	3164
Domestic shipping weight, pounds.....	3275	3564
Export shipping weight, pounds.....	3675	3967
Net weight, pounds, each additional 6" length.....	75	100
Distance—spindle center to floor.....	41½"	43½"
Floor space.....	35" x 83"	35" x 83"
Cubic feet—export.....	125.9	125.9
Box dimensions.....	39" W x 93" L, x 60" H	39" W x 93" L, x 60" H